

Date: Monday, 10/16/2006 2:01:28 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B HIGH GEAR WEB
Job Number	: 29008		
Estimate Number	: 10455		
P.O. Number	: N/A	Part Number	: D26543
This Issue	: 10/16/2006	S.O. No.	: S/A
Prsht Rev.	: NC	Drawing Number	: D2654 REV E1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28403	Drawing Revision	: E1
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 10/30/2006
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM	Qty:	8
		Um:	Each

Additional Product

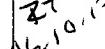
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web B24410 RT/06-10-17 (B)
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1
		<i>M.R 06/10/18</i>
		(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 04/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
06-10-19	2.1	Webs were cut too 80.08, instead of 80.80. Human error by reading the measurement wrong.	 <u>CEFD</u>	Parts are acceptable as per E-mail.	 <u>CEFD</u>	 <u>CEFD</u>	 <u>CEFD</u>	 <u>CEFD</u>	

NOTE: Date & initial all entries

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5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Rm^c 06-10-20 08



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

Rm^c 06-10-20 1

08

08

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/08

Job Completion



U 06-10-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

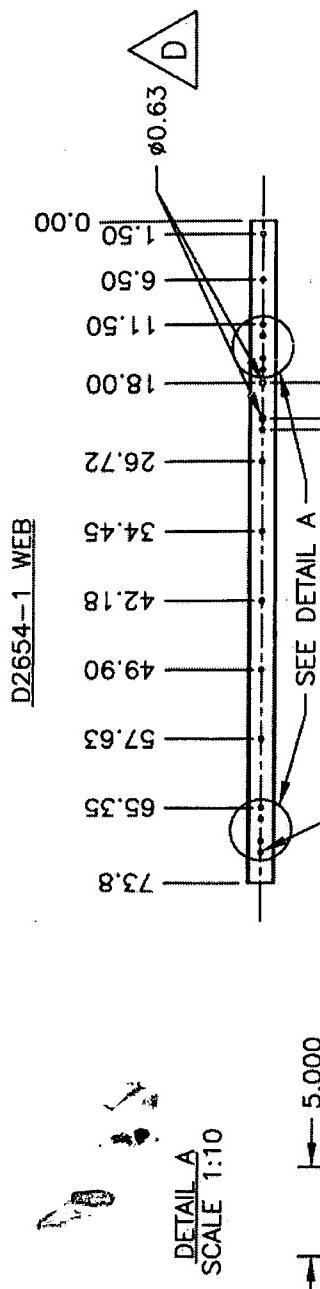
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

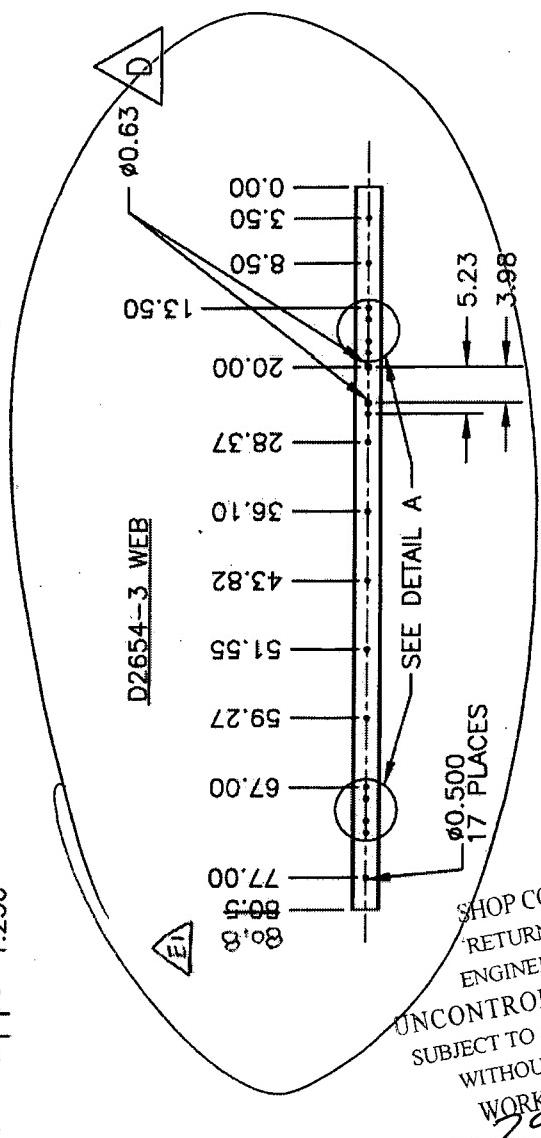
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. E D2654 SHEET 1 OF 2
DATE		TITLE SCALE
04.05.26		WEB 1:20

RELEASED
04.06.22

A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5



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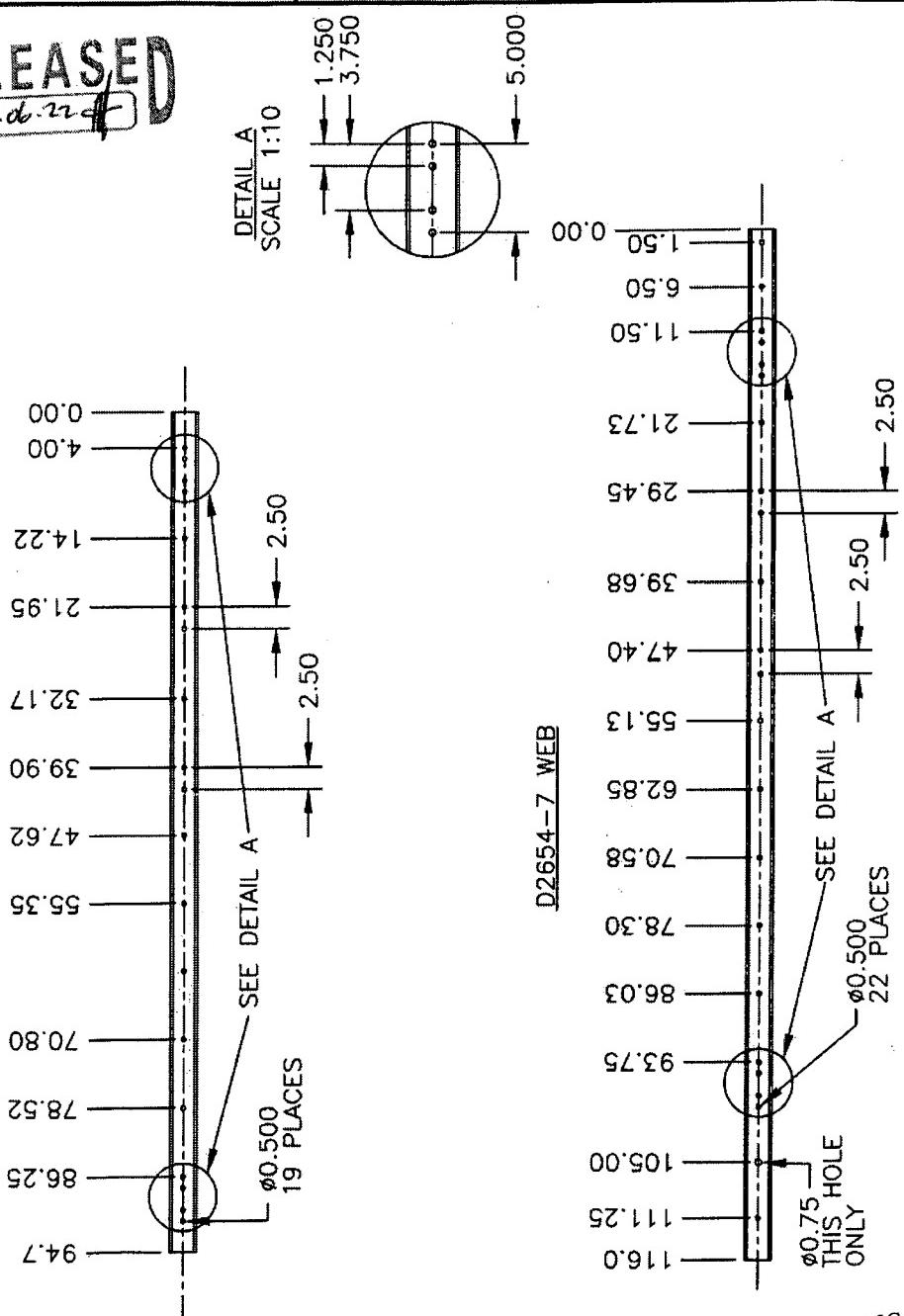
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DESIGN <i>CP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED ✓	APPROVED ✓	DRAWING NO. D2654	REV. E SHEET 2 OF 2	
DATE 04.05.26	TITLE WEB		SCALE 1:20	

RELEASER
04.08.2014

D2654-5 WEB



ONLY
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29008

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, October 19, 2006 10:24 AM
To: 'Chris Provencal'
Cc: 'Jason Murdoch'; 'L Lacelle'
Subject: RE: NCR D2654-3 WEB

Chris/Jason,

Unless you see a problem, I think these parts are acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, October 18, 2006 11:22 AM
To: David Shepherd (David Shepherd)
Cc: 'Jason Murdoch'
Subject: NCR D2654-3 WEB

Qty(8) D2654-3 Webs for the D2650-3 Skidtube: They misread the dwg, they cut the total length to 80.08" instead of 80.8". They are too short on the fwd end, and all the holes have been drilled. Are these parts acceptable?

-Chris

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.5/483 - Release Date: 10/18/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.5/483 - Release Date: 10/18/2006

